

Date: Friday, 4/20/2007 2:09:54 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE RH 206A/B
Job Number	: 31963		
Estimate Number	: 10802		
P.O. Number	: N/A	Part Number	: D206642612
This Issue	: 4/20/2007 S.O. No. : N/A	Drawing Number	: IIN D206-642 REV K
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: K
Previous Run	: 24808	Material	: N/A
Written By	:	Due Date	: 5/10/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.04.23</u>		
Comment	: Est Rev:B 06.10.27 Revised pick list KJ/EC		
	: Est Rev:C 07-02-23 As per IIN D206-642 Rev K JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-612 CHG002

07.05.07 AK

2.0	31963A	FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW
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Comment: Sub-Component FLOAT SKIDTUBE HIGH GEAR 206 A/B
 D206-642-641 B 31963A

7/5/30

SQ

3.0	D206651041	206 A/B GHW Kit
-----	------------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 1 D206651041 GHW Kit Batch: 1330235

4.0	D2652	Bushing
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Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D206 651 041 GHW Adapter

1330816

5.0	D26652	Saddle, RH, Fwd, Aft, Out
-----	--------	---------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2665-2 Saddle

1327671 X 1328980

1320816

7/5/30 SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE RH 206A/B

Job Number: 31963

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2662

Saddle, RH, Fwd,Aft, In



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2662-2 Saddle

1325981

1327111

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

10 D2712 Set Screw

1329962

8.0

D2884

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2884 Saddle Spacer

1329453

9.0

D2885

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2885 Saddle Spacer

1329199

10.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3396-3 Spacer

1326782

11.0

AN3C36A



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 AN3C36A Bolt

⑦ 119349

1101261

7/5/30 SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE RH 206A/B

Job Number: 31963

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN3C41A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN3C41A Bolt

M19349 ✓

13.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN4C6A Bolt

*
M102039 ✓

14.0

AN5C11A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C11A Bolt

M19185 ✓

15.0

AN5C13A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN5C13A Bolt

M18918 ✓

16.0

AN5C32A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C32A Bolt

Ⓢ
M18918 ✓

17.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batc

M18918 ✓

7/5/30 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE RH 206A/B

Job Number: 31963

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN5C35A Bolt M18713

18.0

AN960C10L

washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 AN960C10L Washer M101692 ✓

19.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 AN960C416L Washer M103691 ✓ ✓

20.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN960C516L Washer M19349 ✓ ✓

21.0

MS210433

Nut



Comment: Qty.: 17.0000 Each(s)/Unit Total : 17.0000 Each(s)

Pick:

Qty Part Number Description Batch

17 MS21043-3Nut M103286 ✓

22.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21043-4Nut M104537 ✓

23.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

M101418 ✓
2/5/30 SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: FLOAT SKIDTUBE RH 206A/B

Job Number: 31963

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 MS21043-5Nut

24.0

NAS1515H3L

WASHER



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 NAS1515H3L Washer

MA565 ✓ ✓

25.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 NAS1515H4L Washer

⑧ ⑩
M101542 ✓ M102029 ✓

26.0

NAS1515H5

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 NAS1515H5 Washer

M101925 ✓ ✓

27.0

NAS1515H5L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 NAS1515H5L Washer

M101925 ✓ ✓

28.0

AN5C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C7A Bolt

M19185 ✓ ✓

29.0

AN6C44A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

M103964 ✓ ✓
7/5/30SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: FLOAT SKIDTUBE RH 206A/B

Job Number: 31963

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 AN6C44A Bolt

M103964

30.0

AN960C616

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960C616 Bolt

M19185 ✓ ✓

31.0

MS210436

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 ms21043-6 Nut

M103693 ✓ ✓

7/5/30 *sc*

32.0

D206642641

Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 d206-642-641 Skidtube

31963A

33.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/05/30 *sc*

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-612

Location:

PPP Rev:

REV: A

07/05/30

35.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.05.31

Job Completion



31963A

07/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.7 206A/B High Gear Float Skidtubes (TRI-BAG COMPATIBLE)

Item	Qty -611	Qty -612	Qty -613	Qty -614	Qty -641	Qty -645	Part Number	Description
	X						D206-642-611	SKIDTUBE INSTALLATION, LH
		X					D206-642-612	SKIDTUBE INSTALLATION, RH
			X				D206-642-613	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-614	SKIDTUBE INSTALLATION, RH, THRU BOLT
	1	1	1	1	X		D206-642-641	SKIDTUBE
						X	D206-642-645	WEARSHOE KIT (REPLACES -643 KIT)
	1	1	1	1			D206-651-041	* 206 GHW ADAPTER ⁽³⁾
1					1		D3288-041	SKIDTUBE ASSEMBLY
3					1		D2646	* AFT CAP ⁽¹⁾
4					2		AN3C4A	* BOLT ⁽¹⁾
5A					2		AN960C10L	* WASHER ⁽¹⁾
5B					2		NAS1515H3L	* WASHER ⁽¹⁾
6	1		1				D2665-1	SADDLE, FWD OUT, LH
6		1		1			D2665-2	SADDLE, FWD OUT, RH
7	1		1				D2666-1	SADDLE, FWD IN, LH
7		1		1			D2666-2	SADDLE, FWD IN, RH
8	1						D2665-1	SADDLE, AFT OUT, LH
8		1					D2665-2	SADDLE, AFT OUT, RH
8			1				D2667-1	SADDLE, AFT OUT, LH
8				1			D2667-2	SADDLE, AFT OUT RH
9	1						D2666-1	SADDLE, AFT IN, LH
9		1					D2666-2	SADDLE, AFT IN, RH
9			1				D2668-1	SADDLE, AFT IN, LH
9				1			D2668-2	SADDLE, AFT IN, RH
10	8	8	8	8			AN3C41A	BOLT
11	16	16	16	16			D2652	BUSHING
12A	8	8	8	8			MS21043-3	NUT
12B	16	16	16	16			NAS1515H5	WASHER
13	4	4	4	4			AN5C7A	BOLT
14	4	4	4	4			AN5C11A	BOLT
14A	4	4	4	4			AN5C32A	* BOLT ⁽²⁾
14B	4	4	4	4			MS21043-5	* NUT ⁽²⁾
15A	8	8	8	8			AN960C516L	WASHER
15B	8	8	8	8			NAS1515H5L	WASHER
16	12	12	12	12			AN4C6A	BOLT
17A	24	24	24	24			AN960C416L	WASHER
17B	24	24	24	24			NAS1515H4L	WASHER
18	12	12	12	12			MS21043-4	NUT
20A					7	7	D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1	D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1	D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B					1	1	D3536-15	* GASKET ⁽¹⁾
23A					1	1	D3535-21	* WEARSHOE ⁽¹⁾ (REPLACES D2656-21)
23B					1	1	D3536-21	* GASKET ⁽¹⁾
24A					1	1	D3535-41	* WEARSHOE ⁽¹⁾ (REPLACES D3287-3)
24A					1	1	D3536-41	* GASKET ⁽¹⁾
25A					1	1	D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B					1	1	D3536-35	* GASKET ⁽¹⁾
26A					64	64	AN3C4A	* BOLT ⁽¹⁾
26B					64	64	AN960C10L	* WASHER ⁽¹⁾
26C					64		ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
28	2	2	2	2			AN6C44A	BOLT
29A	2	2	2	2			MS21043-6	NUT
29B	4	4	4	4			AN960C616	WASHER

continued on next page...

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WORK ORDER
NO. 31963

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Revision: K

Date: 06.09.25

continued from previous page...

Item	Qty -611	Qty -612	Qty -613	Qty -614	Qty -641	Qty -645	Part Number	Description
34					1		AN4C5A	BOLT
35					1		AN960C416	WASHER
36					1		D3413-1	RING
37	10	10	5	5			D2712	SET SCREW
38	2	2	2	2			D2884	SADDLE SPACER
39	2	2	2	2			D2885	SADDLE SPACER
50	9	9	9	9			AN3C36A	BOLT
52	18	18	18	18			AN960C10L	WASHER
53	18	18	18	18			NAS1515H3L	WASHER
54	9	9	9	9			MS21043-3	NUT
55	2	2	2	2			D3396-3	SPACER
56A	1	1	1	1			AN5C35A	BOLT
56B	1	1	1	1			AN5C13A	BOLT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3288-041 ASSEMBLY ABOVE
 (2) MAY BE REQUIRED ON -613/-614 INSTALLATIONS OR DART CROSSTUBES
 (3) NOT INSTALLED AS PART OF SKIDTUBE. USED TO MODIFY OEM GROUND HANDLING WHEELS

5.0 WEIGHT AND BALANCE:

5.1 D206-642-111/-112/-211/-212/-311/-312/-411/-412 Skidtubes and Saddles

The following weight and balance information is for Dart D206-642-111/-112/-211/-212/-311/-312/-411/-412 skidtube and saddle installations only. The weight and balance of the skidtube and saddle installations that are being removed from the aircraft are the responsibility of the installer.

Note that the long wearshoe and ground handling kits are optional installations for flight. Weights for these (*) items should be subtracted if they are removed or otherwise not installed.

5.1.1 206 A/B Low Gear Skidtubes

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
D206-642-111	17.4 lb	96.3 in	1676 in lb	-36.8 in	-640 in lb
206A/B LOW, LH	7.9 kg	2.44 m	19.3 m kg	-0.93 m	-7.3 m kg
D206-642-112	17.4 lb	96.3 in	1676 in lb	36.8 in	640 in lb
206A/B LOW, RH	7.9 kg	2.44 m	19.3 m kg	0.93 m	7.3 m kg
*D206-642-143	2.0 lb	96.3 in	193 in lb	+/- 36.8 in	+/- 74 in lb
WEARSHOE KIT	0.9 kg	2.44 m	2.2 m kg	+/- 0.93 m	+/- 0.8 m kg

5.1.2 206 A/B High Gear Skidtubes

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
206-642-211	18.6 lb	93.8 in	1745 in lb	-37.3 in	-694 in lb
206A/B HIGH, LH	8.4 kg	2.38 m	20.0 m kg	-0.95 m	-8.0 m kg
D206-642-212	18.6 lb	93.8 in	1745 in lb	37.3 in	694 in lb
206A/B HIGH, RH	8.4 kg	2.38 m	20.0 m kg	0.95 m	8.0 m kg
D206-642-213	18.6 lb	93.8 in	1745 in lb	-37.3 in	-694 in lb
206A/B HIGH, LH, THRU	8.4 kg	2.38 m	20.0 m kg	-0.95 m	-8.0 m kg
D206-642-214	18.6 lb	93.8 in	1745 in lb	37.3 in	694 in lb
206A/B HIGH, RH, THRU	8.4 kg	2.38 m	20.0 m kg	0.95 m	8.0 m kg
*D206-642-243	2.2 lb	93.8 in	206 in lb	+/- 37.3 in	+/- 82 in lb
WEARSHOE KIT	1.0 kg	2.38 m	2.4 m kg	+/- 0.95 m	+/- 1.0 m kg

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Revision: K

Date: 06.09.25

Date: Friday, 4/20/2007 2:10:58 PM
User: Kim Johnston

Process Sheet

Customer:	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW
Job Number	: 31963A		
Estimate Number	: 10803	Part Number	: D206642641
P.O. Number	:	Drawing Number	: D3288 REV C
This Issue	: 4/20/2007 S.O. No. :	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: C
First Issue	: 1 / Type : LANDING GEAR	Material	:
Previous Run	: 31962A	Due Date	: 5/10/2007 Qty: 1 Um: Each
Written By	:		
Checked & Approved By	: <u>JA 07.04.23</u>		
Comment	: Est Rev:B 05-11-15 Added washers for aft cap, wearshoes and ring EC		
	: Est Rev:C 06-05-31 Revised steps JLM		
	: Est Rev:D 07-02-22 Added SS Wearplates & Gaskets JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-641 CHG002

N/A 07.04.23

2.0	D2620	Bent 206 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2620 3" OD Bent Tube	<u>32487</u>	B 31487 Pm 07-04-24
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3.0	D2647	Cap
-----	-------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2647 Fwd Cap	<u>29328</u>	BE 07-04-24
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4.0	D32861	Doubler
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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2	D3286-1 Doubler	<u>829090</u>	Pm 07-04-25
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 4/20/2007 2:10:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 31963A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr FWD edge of tube, grind bending marks.

Pm 07-04-240

2-Remove ridge on inside of fwd edge of tube as per Dwg D3288.

Pm 07-04-240

3-Weld Fwd Cap as per Dwg D3288, Grind to obtain proper fit

AVR AL ROD

Batch: *M 102421 BE 07-04-24*

4-Grind welds flush to cap on top surface only.

BE 07-04-24

5-Cut Aft end as per Dwg D3288 from front of tube then deburr

Pm 07-04-250

6-Remove inner indexing ridge on aft end as per Dwg d3288

7-Open holes for aft cap as per Dwg D3288 using Dt8025

8-Drill pilot holes using DT8818

9-Insert D3286-1 doubler using DT8732 & DT8879, then locating doubler off the D3286-1 doubler, leave Dt8732 for added support

3/16" holes cleco

10-Drill D3286-1 doubler rivet holes in tube using #40 drill, spot drilling doubler at the same time.

11-Working from center out, drill #30 holes into D3286-1 Doubler. cleco each hole after its drilled, Verify angle of holes to accomodate rivet heads.

12-Remove 3/16" clecos only and open GHW holes to .500" as per Dwg D3288.

13-Remove D3286-1 doubler, identify orientation, deburr then attach to W/O

14-Remove indexing edge as per Dwg D3288.

Pm 07-04-260

15-C'sink rivet holes as per Dwg D3288.

Pm 07-04-300

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP





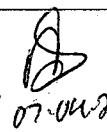
AD

7-4-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-04-27		holes slightly ovalized during countersinking  Said		SH in and re-drill & countersink	BE 07-04-30	 07-05-09	 ASDUR	 07-04-27

NOTE: Date & initial all entries

Date: Friday, 4/20/2007 2:10:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 31963A

Part Number: D206642641

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 07-04-30

9.0	CR3212404	Cherry Rivet
-----	-----------	--------------



Comment: Qty.: 52.0000 Each(s)/Unit Total: 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet

M10134

(28)

M102909

(24)

Pm 07-05-01 (1)

10.0	D3289041	Float Web (206A/B)
------	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3289-041 Float Web

B24864

Pm 07-05-01 (1)

11.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
------	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D3288. Micro-shave rivets as required.

Pm 07-05-01 (1)

2-Bond web in place as per Dwg D3288 & QSI 015.

A/R Sikaflex-291

M103561

Sikaflex expire date:

07-00-01

Start: 07-05-01

Time: 7:30am

Finish: 7-5-2

Time: 7:30am L2

(Adhere for 12 hours)

Pm 07-05-01 (1)

12.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

DP 7-5-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 4/20/2007 2:10:58 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 31963A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube using program D3288 as per Dwg D3288. Install drop pins in cross bolt spacer holes to maintain web position. *EL 7-5-2*

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes for wearplates using D3288-T2 as per Dwg D3288, then open to Ø0.297". (without cutting fluid) *pm 07-05-02*

DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)

2-Open x-BOLT holes as per Dwg D3288. *Done At Seq # 11 pm 07-05-01 ①*3-C'sink X-bolt holes. *pm 07-05-02*4-Debur *pm 07-05-02*

15.0

D2649

Crossbolt Spacer



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 D2649 Crossbolt spacer *B 28250 BE 07-05-02*

16.0

D32751

Crossbolt Spacer



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 D3275-1 Crossbolt spacer *B 21748 BE 07-05-02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 4/20/2007 2:10:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 31963A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3286-3

Spacer

B-29015 BE 07-05-03

18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3288. Remember to back drill each hole before welding the other side. Use aluminum rod.

A/R Aluminum Rod

M 102421 BE 07-05-02

2-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3288. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required

A/RSS Rod

M 10275C BE 07-05-03

3-Grind welds flush to Fwd cap on top surface only.

4-Grind cross bolt welds flush as per Dwg D3288. Masking Tape access to inside of the skidtube

Pm 07-05-03 (1)

5-Counterbore 5/16" x 0.750" deep using DT8747, except 8th cross bolt hole from Aft end, as per Dwg D3288.

Pm 07-05-03 (2)

19.0

QC5/a

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/03

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07-05-04 (1)

21.0



QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/05/08 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/05/03	19.0	Permanent change add Qc 9 inspection	E	07.06.12		 07.06.12	 07/05/03

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 4/20/2007 2:10:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 31963A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate 630837

23.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivet m14651

24.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CR3212-4-03 Rivet m15918

25.0

ALS71032130

Insert



Comment: Qty.: 64.0000 Each(s)/Unit Total : 64.0000 Each(s)

Insert

Batch: m102475

FEL

07/05/08

26.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D3415-041 Nut Plate as per Dwg D3288, Install with LPS-3

A/R LPS-3 Batch: m104161

2-Install inserts Dwg D3288. Use a drop of Sikaflex inside insert holes

A/R Sikaflex-291 m103561

Sikaflex expire date: 07/10

FEL 07/05/08 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 4/20/2007 2:10:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 31963A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Inserts & Nut plate

07/05/08

28.0

D353515

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B31990

29.0

D353521

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B31991

30.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B31992

31.0

D353541

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B31993

32.0

D353615

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: B31994

33.0

D353621

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: B31995

FL

07/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Friday, 4/20/2007 2:10:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 31963A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B30755

35.0

D353641

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B31997

36.0

D35371

WEARPAD



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

WEARPAD

Batch: B3998 (x6)

37.0

D35373

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

Batch: B31726

38.0

AN3C4A

BOLT



Comment: Qty.: 66.0000 Each(s)/Unit Total : 66.0000 Each(s)

BOLT

Batch: M104322

39.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 NAS1515H3L Washer ~~M103641~~ M103641

40.0

AN960C10L

washer



Comment: Qty.: 64.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number Description Batch

fed 07/05/08 (P)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 4/20/2007 2:10:58 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 31963A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

64 AN960C10L Washer *M104215*

41.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3413-1 Ring *B29869*

42.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 AN4C5A Bolt *M18918*

43.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
~~1 AN960JD416 Washer~~ *M100651 M-R*
~~AN960JD416~~ *1X AN960C416**PTO*

44.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2646 Aft Cap *B30119*

45.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 AN960C10L Washer *M104215**For 07/05/08 (1)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0705-30	43.0	AN960C416 is required. perm. change. Remove AN960JD416 washer.	EC	0706-12		0705-30	0705-30

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 4/20/2007 2:10:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 31963A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

46.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2-Install wearshoes/wearpads & Gaskets as per Dwg D3288.

3-Install Ring on Nut Plate as per detail F & Dwg D3288.

4-Spray inside tube with LPS-3 on both sides of web

5-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291

Sikaflex expire date:

m103561
07/10

6-Coat all exposed fastners with LPS Procyon, remove any excess on powder coat with MEK Degreasser.

A/R LPS Procyon

Batch: m104161

Feb
07/05/08 ①
install wearplate
07/05/30
1331998 *Feb*

47.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/30

48.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-641

Location: _____

PPP Rev: _____

Rev A

7/5/30

sq *7/5/30*

49.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3288	REV. C SHEET 1 OF 3
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.05.17	NEW ISSUE	
B	05.03.16	CHANGE INSERTS	
C	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED07.02.12 **[Signature]**

Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2647	CAP
1	D2646	AFT CAP
9	D2649	CROSS BOLT SPACER
9	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN960C416	WASHER
66	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH:
 - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
 - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

SHOP COPY

RETURN TO

ENGINEERING

CONTROLLED COPY

SUBJECT TO AMENDMENT

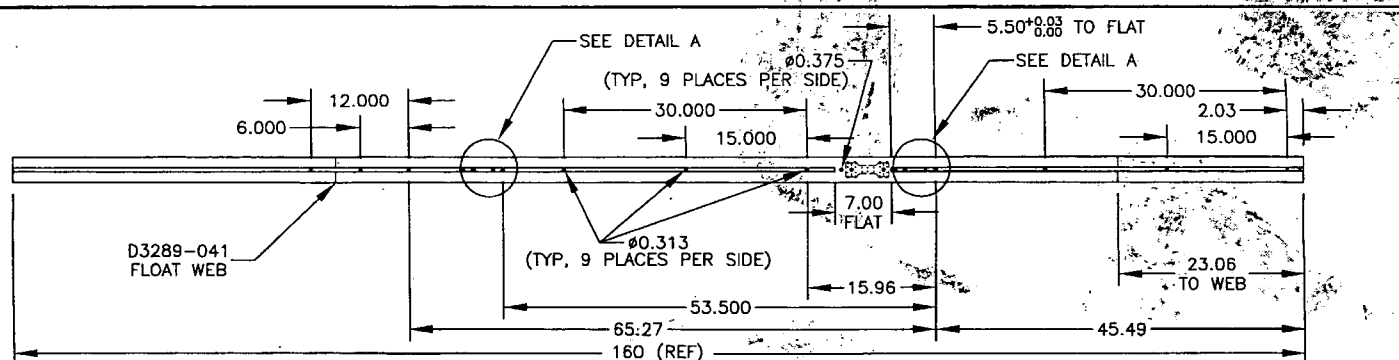
WITHOUT NOTICE

WORK ORDER

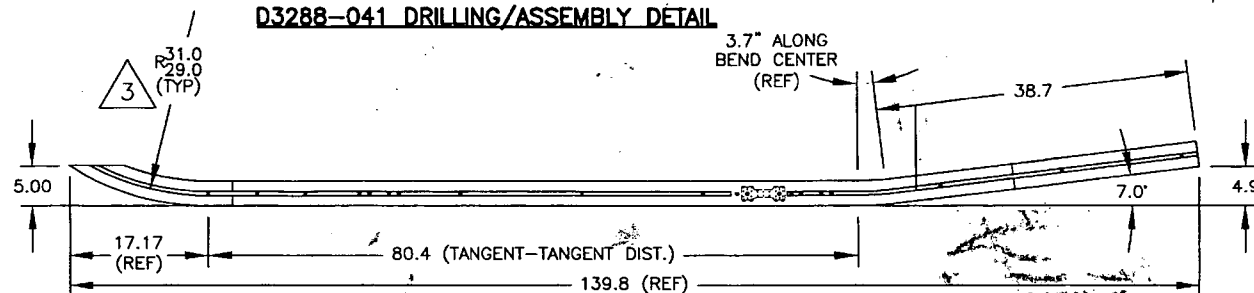
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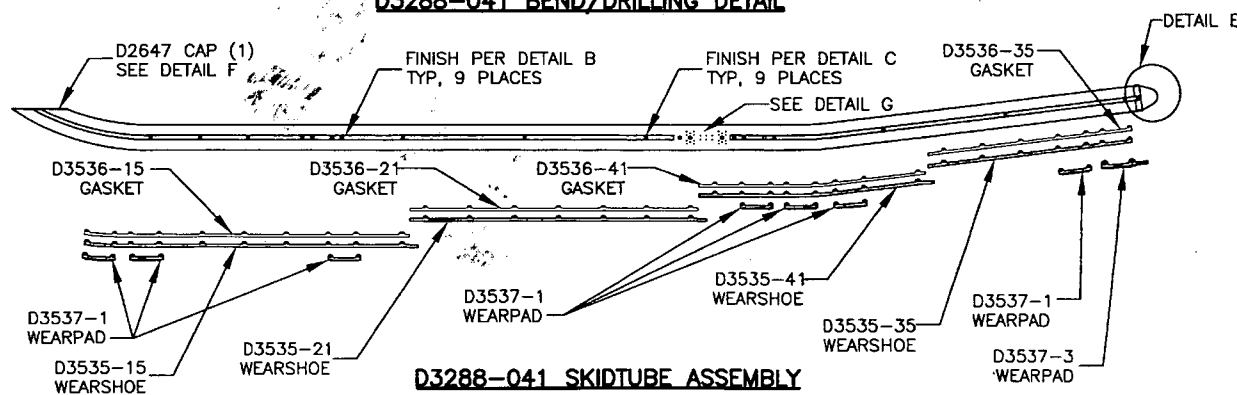




D3288-041 DRILLING/ASSEMBLY DETAIL



D3288-041 BEND/DRILLING DETAIL



D3288-041 SKIDTUBE ASSEMBLY

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31963A

07.02.12

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		DATE	06.12.19			D3288	SHEET 2 OF 3
		TITLE				SKIDTUBE ASSEMBLY	SCALE
							1:15

1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO $\varnothing 0.313 \times 0.75$ DEEP

D3275-1 SPACER

CHAMFER 0.030x45° (TYP)

DETAIL G
SCALE 1:5

DRILL #30
C'SINK $\phi 0.229 \times 100$
INSTALL CR3212-4-04
RIVET (26 PER DOUBLER)

D3286-1
DOUBLER (2)
(1 PER SIDE)

H

H

ENLARGE TO $\phi 0.500$ IN D3286-1
ENLARGE TO $\phi 0.625$ IN TUBE
(2 PLACES PER SIDE)

-GASKET/WEARSHOE/WEARPAD (REF)

AN4C5A BOLT (1)
AN960C416 WASHER (1)
INSTALL WITH SIKAFLEX-241/-291

CCR264SS3-3 RIVETS (2 PLACES)
INSTALL WITH LPS-3

CR3212-4-03 RIVETS (2 PLACES)
INSTALL WITH LPS-3

D3415-041 NUT PLATE,
LPS-3 ON FAYING SURFACE,
LPS HARDCOAT ON EXTERIOR

D2647 CAP (REF)

D3413-1 RING

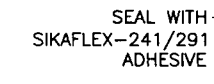
1.0
REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.

EX-241/-291

DETAIL F NO.

AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

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D2646 CAP

SEAL WITH SIKAFLEX-241/291 ADHESIVE

NAS 1515H3L (2 PLACES) INSTALL WITH

Ø0.208 (2 PLACES) DRILL PRIOR TO INSTALLING D2646 CAP

BORE OUT END OF SKIDTUBE TO 0.75 DEPTH AND 0.070 WALL

0.400

0.425 (TYP)

SECTION H-H
NOT TO SCALE




D3286-3 SPACER
(2 PLACES)

D3286-1 DOUBLER
(REF)

2. TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
3. ENLARGE HOLES IN D3286-1 TO $\phi 0.500$
4. ENLARGE HOLES IN TUBE TO $\phi 0.625$
5. RIVET D3286-1 TO TUBE
6. INSERT D3286-3 SPACER
7. WELD IN PLACE AND GRIND FLUSH

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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	CHECKED 	APPROVED 	DRAWING NO. D3288	REV. C SHEET 3 OF 3
	DATE 06.12.19	TITLE SKIDTUBE ASSEMBLY		SCALE 1:3

NO. 106

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number 206642241 / B31880A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☒ Partial ☐ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/04/27 Qualifier David Amel